



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5632-042
Job Sheet 198124-A



Part No: D5632-042

Job Qty: 15 pcs

Part Name: MID Wearplate, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/19/19

Job Tracking No:

Due Date: 8/23/19

Created By: Eric Larocque

Type: SOLD

Description:

Note: D5632 REV.A9 IPP REV:A 18.05.22 NEW ISSUE DD VERF:JFS IPP REV:B 18.07.19 AS PER DWG REVA.8
DD VERF:JFS IPP REV:C 18.10.30 AS PER DWG REV.A9 DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
150	QC 5	15 pcs	8/23/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
160	Large Fab - Welded Assy-2-B4B	15 pcs	8/23/19		0.00	3.00	Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
							Large Fab - 11 - B4B (Various)		

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Container No: S204006



Part: D5632 - 042

Job No: 198124 - A

Serial No/Batch: S204006

Revision: A9

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/19/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
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170 QC 9	15 pcs	8/23/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	CR
				QC 9 - 9	
				QC 5 - 10	
180 QC 5	15 pcs	8/23/19	0.00 0.00	QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	CR
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190 Handfinish - 4-1-Assembly-B4B	15 pcs	8/23/19	0.00 3.75	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	RD 17-8-19
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
200 QC 3	15 pcs	8/23/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	DAS
				QC 3 - 59	81
				QC 3 - 68	9-89
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	

				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
210 Packaging 3-1 - Stock - B4B	15 pcs	8/23/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	Pc ST260B
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	15 pcs	8/23/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 150 - (QC5- Inspect part completeness to step on W/O)

Descriptions: 160 - -Tack weld as per dwg. -Index clamp as per dwg note 10

170 - (QC9- Inspect visual per QSI004- Fusion Welds)

180 - (QC5- Inspect part completeness to step on W/O)

190 - HandFinish4 (Assemble as per dwg) 1- APPLY TEXTURED COATING ON CONCAVE SURFACE ****AS PER NOTE 9**** ON DWG AND QSI BATCH: Be attached 2- AS PER DWG NOTE 12, INDICATE FWD DIRECTION.

200 - (QC3- Inspect Part Finish)

210 - (Identify as per dwg & Stock Location: LOCATION : FP001

220 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D5641-1	Clamp	30 pcs (2 ea)	160-Large Fab - Welded Assy-2- B4B	J205826

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
160-Large Fab - Welded Assy-2- B4B	D5641-1	30	60	0
Part Specifications				
Specifications could not be found.				

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D5632-042
Job Sheet 198124



15

Part No: D5632-042

Job Qty: 18 pcs

Part Name: MID Wearplate, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/22/19

Job Tracking No:

Due Date: 8/23/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D5632 REV:A9 IPP REV:A 18.05.22 NEW ISSUE DD VERF:JFS IPP REV:B 18.07.19 AS PER DWG REVA.8
DD VERF:JFS IPP REV:C 18.10.30 AS PER DWG REVA9 DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off		
					Setup Hrs	Run Hrs	Workcenter / Supplier					
110	Waterjet - Flow - 1	18 pcs		8/23/19	0.17	1.80	Waterjet - Flow			JRB 8/6/19		
120	QC 2	18 pcs		8/23/19	0.00	0.00	QC 2 - 1					
SEE ATTACHED											QC 2 - 12	
											QC 2 - 14	
											QC 2 - 17	
											QC 2 - 19	
											QC 2 - 2	
											QC 2 - 20	
											QC 2 - 22	
											QC 2 - 23	
											QC 2 - 25	
											QC 2 - 32	
											QC 2 - 33	
											QC 2 - 35	
											QC 2 - 39	
											QC 2 - 4	
											QC 2 - 40	
											QC 2 - 44	
											QC 2 - 45	
											QC 2 - 48	
											QC 2 - 49	
											QC 2 - 50	
											QC 2 - 51	
											QC 2 - 52	
											QC 2 - 57	
											QC 2 - 62	
QC 2 - 63												
QC 2 - 8												
QC 2 - 66												
QC 2 - 64												

SEE ATTACHED

130 QC 8	18 pcs	8/23/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB 8/4/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	ATIG 1-2 2019 DAS 40 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Small Fab - Brake NC - B4B	18 pcs	8/23/19	0.25 0.60	Small Fab - Brake - 1 - B4B	DAS 30 9-89 AUG 12 2019
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
150 QC 5	18 pcs	8/23/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	AUG 13 2019 DAS 40 9-89
				QC 5 - 61	
				QC 5 - 81	
160 Large Fab - Welded Assy-2-B4B	18 pcs	8/23/19	0.00 3.60	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	MJ
				Large Fab - 4 - B4B	

				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
170 QC 9	18 pcs	8/23/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
180 QC 5	18 pcs	8/23/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190 Handfinish - 4-1-Assembly-B4B	18 pcs	8/23/19	0.00 4.50	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
200 QC 3	18 pcs	8/23/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
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				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				Plex 7/22/19 1:14 PM Dart.lajeunesse.marie	

					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
210 Packaging 3-1 - Stock - B4B	18 pcs	8/23/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
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					Packaging 3 - 7 - B4B	
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					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
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					Packaging 3 - 17 - B4B	
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					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
220 QC 21 - SA	18 pcs	8/23/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 110 - 1-Cut D5632-1F as per Dwg D5632 Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Form as per dwg)

150 - (QC5- Inspect part completeness to step on W/O)

160 - -Tack weld as per dwg. -Index clamp as per dwg note 10

170 - (QC9- Inspect visual per QSI004- Fusion Welds)

180 - (QC5- Inspect part completeness to step on W/O)

190 - HandFinish4 (Assemble as per dwg) 1- APPLY TEXTURED COATING ON CONCAVE SURFACE ****AS PER NOTE 9**** ON DWG AND QSI BATCH: 5300412 2- AS PER DWG NOTE 12, INDICATE FWD DIRECTION.

200 - (QC3- Inspect Part Finish)

210 - (Identify as per dwg & Stock Location: LOCATION : FP001)

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	30.6000 sf (1.7 ea)	110-Waterjet - Flow - 1	5188581x21
D5641-1	Clamp	36 pcs (2 ea)	160-Large Fab - Welded Assy-2- B4B	5205926

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S18GA	31	266	0
160-Large Fab - Welded Assy-2- B4B	D5641-1	36	0	0

Part Specifications

Specifications could not be found.

Plex 7/22/19 1:14 PM Dart.lajeunesse.marie

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Quality ☐					
Date :	Sequence #:	QTY Affected :		MRB (QS1042)					
Description Work Order Deviation				Disposition					
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread					
Completed By				Lead hand / Supervisor					
QC / QA Coordinator									